

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000331**Date Inspected:** 01-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** MTR & WQT**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger observed welder qualification testing (WQT) by Moody International Inspectors Feng Lin Yao, Tang Li Pang, Certified Welding Inspector Zhou Daqing and He Jia Min at ZPMC today. There were no ZPMC Certified Welding Inspectors today however there were four assistants and one American Bridge/Fluor employees Mr. Danny Mc Donald. There were a total of 61 welders which attempted welder qualification test for yesterday in the shield metal arc (SMAW), submerged arc (SAW) and the flux cored arc (FCAW) welding process. There were of total of 30 FCAW welder tests attempted with 18 passing final visual inspection, and a total of 23 SMAW tests attempted with 15 passing final visual inspection and a total of 5 SAW tests attempted with 1 passing final visual inspection. Moody International Certified Welding Inspector Zhou Daqing performed the final visual inspections. The Moody International, ZPMC and ABF inspectors were observed checking the welding parameters for the welders being tested. A random inspection was made of the various volt/amp gauges and temperature gauges for calibration of which all were found to be in a current state of calibration.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger observed material received in the ZPMC yard today. There were a total of 20 plates received for mock-ups with thicknesses ranging from 20 millimeters to 100 millimeters. The plates were all ASTM A709M-HPS-485WT2-Z; A709-50T-2; A709-50-2A25 or A709-50F-2 material and were accompanied with material test reports (MTR). The MTRs could not be reviewed on the day

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the plates were observed for their general condition and markings but will be reviewed at the earliest opportunity.
Assigned lot number B72-079-07 to this lot of plate.



Summary of Conversations:

No relevant conversations took place on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
